1. MAY 16 1919

1866

RGING-MACHINING-HEAT TREATING
3-4 in. 50 CAL U. S. NAVY GUNS.

The billet of steel, ordinarily of large diameter, is placed in a furnace, the fuel of which is oil under high pressure. When at the proper heat the steel is placed under hydraulic press. The billet is pressed in such a manner that it is elongated, which keeps all fibres of the steel intact the entire length of forging. This is the process for making the jackets and also the tubes for guns. From here it is conveyed by traveling crane to a large lathe and rough turned inside and out. The jacket of gun is the outer casing, and the tube is the rifled tube, which fits inside the jacket. The tube is then rough turned inside and out. The next operation is hardening it in a vertical electric furnace, also controlled by electricity. When at proper heat the jacket or tube, for it is the same process for either, is drawn out by overhead crane and immersed in water. After which it is placed in an annealing furnace, which makes the jackets or tubes workable in the lathes for other operations. On either end of turned forging is left about 6 inches surplus of stock. In this space they extract samples of the steel in this particular piece of steel. These samples go to the Government inspectors. After which, if the samples are good quality, the process of gurr making in this forging may go on. The gun forging is then placed in lathes and turned to rough size. In the McMyler plant the guns are turned to rough sizes only, being finished at some other gun factory.

The McMyler Interstate Co
Bedford Ohio

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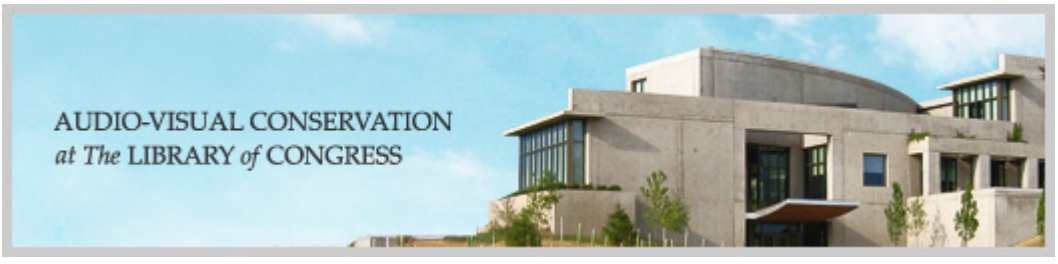

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